

Date: Tuesday, 1/29/2008 12:54:58 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW LUG
 Job Number : 37061
 Estimate Number : 11217
 P.O. Number : Part Number : D34041
 This Issue : 1/29/2008 S.O. No. : Drawing Number : D3404 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 35810 Material :
 Written By : Due Date : 2/15/2008 Qty: 60 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A 05.09.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0750X2500 304 BAR .750 X 2.5



Comment: Qty.: 0.2406 f(s)/Unit Total : 14.4333 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M105802

EC 08.01.29

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: 2.750" long

EC 08.01.29

(61)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Issue P.O. 5565

cd 08/01/20

Machine per drawing D3404 Rev B

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: Folio Rev:

2-Deburr

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit damage

ensure 6 of 10 checked / 1/24/08 (57)

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect level 5

2008-02-22

(57) counted

(PTO)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: N/A Fault Category: Supplier/Mater NCR: Yes No DQA: 1D Date: 08/02/27
 QA: N/C Closed: 1D Date: 08/02/27

NCR: <u>37061</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0802-22	3.0	14 parts scrap from Supplier sub-contractor parts were faced too thin.	<u>[Signature]</u> 08/02/27	scrap; destroy qty 4 no replace.	<u>FC</u> 08/02/27	<u>[Signature]</u> 08-02-27	<u>[Signature]</u> 08/02/27	<u>[Signature]</u> 08-02-27

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW LUG

Job Number: 37061

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 45

PC 08 02 27 (57)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/27 (57)

Job Completion



mi 2008/2/27 (57)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

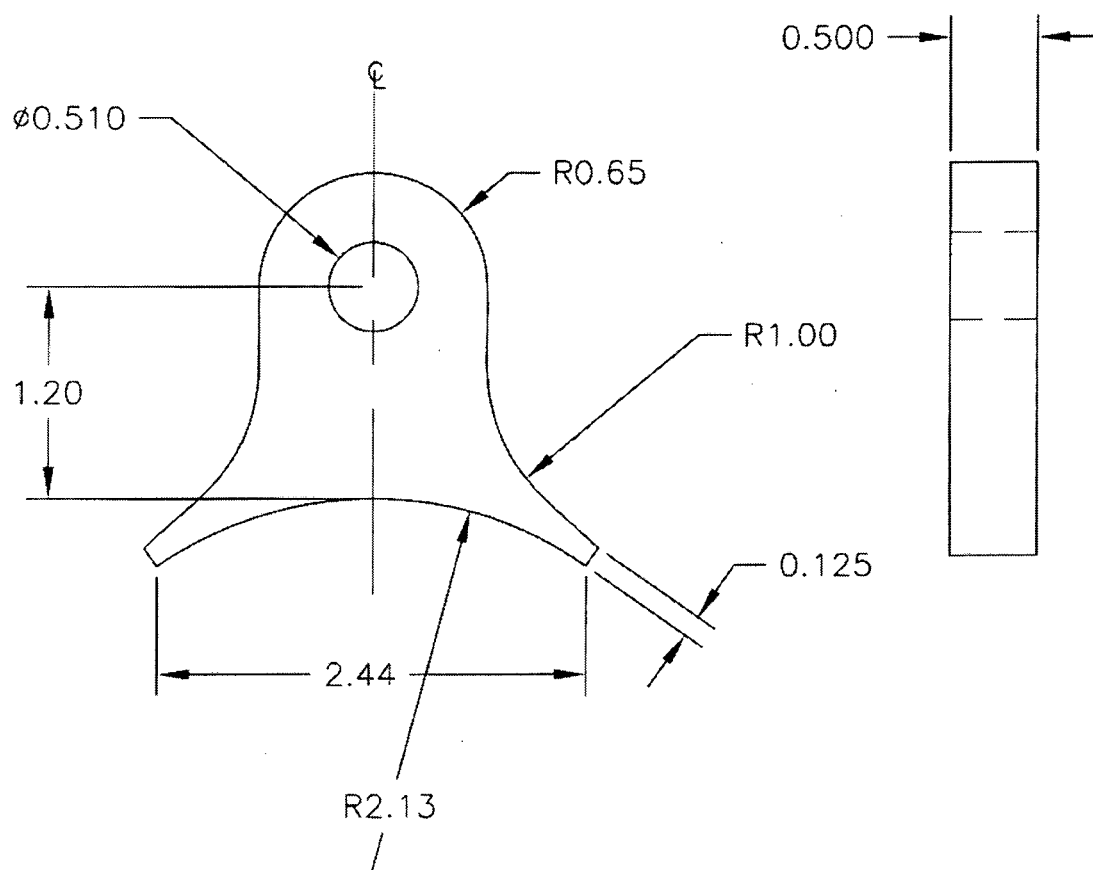
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3404	REV. 8 SHEET 1 OF 1
DATE 05.06.14		TITLE GHW LUG	SCALE 1:1
A	05.03.08	NEW ISSUE	
B	05.06.14	UPDATE M-SPEC	

RELEASED
11-05-08-09 [Signature]



D3404-1

D3404-1 GHW LUG

- 1) MATERIAL: AISI 304/316 SS BAR
(REF. DART SPEC. M304B0.750X02.500)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP CORNERS 0.03 TO 0.06
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O : 37061
C208/01/29

**CERTIFICATE OF CONFORMITY**

Att. Chantal

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

57

D3404-1 ✓

Lug B37061

P5565

MATERIAL: supplied by DART M304B0750X2500 M105802

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

For

Vankleek Hill, February 21, 2008